

Date: Friday, 16/01/2009 8:28:14 AM  
 User: Chantal Lavoie

## Process Sheet

|                                    |                                     |                           |                        |
|------------------------------------|-------------------------------------|---------------------------|------------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b> :     | AFT DOOR ASSEMBLY      |
| <b>Job Number</b> :                | 44861                               | <b>Part Number</b> :      | D350588041 <i>2445</i> |
| <b>Estimate Number</b> :           | 12103                               | <b>Drawing Number</b> :   | D2445, D350-588 P5-6   |
| <b>P.O. Number</b> :               |                                     | <b>Project Number</b> :   | N/A                    |
| <b>This Issue</b> :                | 16/01/2009                          | <b>Drawing Revision</b> : | D,D                    |
| <b>Prsht Rev.</b> :                | NC                                  | <b>Material</b> :         |                        |
| <b>First Issue</b> :               | 1/1                                 | <b>Due Date</b> :         | 16/02/2009             |
| <b>Previous Run</b> :              | 44860                               | <b>Qty:</b>               | 1 Um: Each             |
| <b>Written By</b> :                | <i>[Signature]</i>                  |                           |                        |
| <b>Checked &amp; Approved By</b> : | <i>C209/10/16</i>                   |                           |                        |
| <b>Comment</b> :                   | Est P 04.02.04 Reformat KJ/DS       |                           |                        |

*No Kit sold alone BE 8209 u*

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |    |                  |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

|     |    |            |
|-----|----|------------|
| 2.0 | PG | PURCHASING |
|-----|----|------------|

**Comment:** PURCHASINGIssue P/O: *7995*

Description: D2445 Baggage Door

Supplier: Delastek

Ship to Delastek (1) D0588-041 label

Certification of Conformity and process sheet from Delastek is required.

|     |       |               |
|-----|-------|---------------|
| 3.0 | D2445 | Aft Door, 350 |
|-----|-------|---------------|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Door

|     |             |                       |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure Certificate of Conformity &amp; Process Sheet are attached

|     |     |                   |
|-----|-----|-------------------|
| 5.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

Inspect as per Dwg D2445.

Audit process sheet.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 8:28:14 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 44861

Part Number: D350588041 *D2445*

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2143

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2143 Hinge Doubler *33882* *NA*

7.0

D2144

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2144 Hinge Doubler *41174*

8.0

D2463

Seal



Comment: Qty.: 7.2500 f(s)/Unit Total : 7.2500 f(s)

Neoprene Seal

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2463-0870 1/2" Foam Seal *43841*

9.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2585 Latch Clamp *BH5888*

10.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2586 Latch *BH5554*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 8:28:14 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 44861

Part Number: D350588041

D2445

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

Pick: Assembly Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2   | D2621       | Latch Plate | 33894 |

SS 09/02/17

12.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description         | Batch |
|-----|-------------|---------------------|-------|
| 1   | D2857-1     | Lower Hinge Bracket | 4466  |

SS 09/02/17

13.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description         | Batch |
|-----|-------------|---------------------|-------|
| 1   | D2857-2     | Upper Hinge Bracket | 39786 |

SS 09/02/17

14.0

AN526C832R9

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 8   | AN526C832R9 | Screw       | 110372 |

SS 09/02/17

15.0

AN960JD8

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 8   | AN960JD8    | Washer      | 110382 |

SS 09/02/17

16.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 2   | AN960JD10   | Washer      | 110139 |

SS 09/02/17

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 8:28:14 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 44861

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 MS21042L08 Nut (or -08)

M109174

SS 09/02/17 (X)

18.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut (or -3)

M109798

SS 09/02/17 (X)

19.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-15 Screw

M109321

SS 09/02/17 (X)

20.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble all of the above parts as per Dwg D350-588

BR 09-03-3 (1)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 09/03/03 (X)

22.0

D2150

Packer Doubler, Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2150

Hinge Packer

39780

SS 09/03/04 (X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 44861

Part Number: D350588041

D2445

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2151

Packer Doubler, Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2151

Hinge Doubler

44889

N/A

SS 09/03/04 (X)

24.0

D2153

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2153

Gas Spring Assy

41421

SS 09/03/04 (X)

25.0

D2154

Stud Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2154

Stud Bracket

1345814

2/3/04

(10)

SS

26.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Pick: Assembly Kit

Qty

Part Number

Description

Batch

2 D2237

Striker Plate

43938

W

SS 09/03/04 (X)

27.0

D2461

Neoprene "D" Seal



Comment: Qty.: 7.2500 f(s)/Unit Total : 7.2500 f(s)

Neoprene "D" Seal

Pick: Kit Picking

Qty

Part Number

Description

Batch

1 D2461-0870

Neoprene 'D' Seal

39782

measured by ED

SS 09/03/04 (X)

28.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2589

Keys, Key Chain

838814

SS 09/03/04 (X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 8:28:14 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 44861

Part Number: D350588041

D2445

Job Number:



Seq. #: Machine Or Operation: Description :

29.0 D28581 Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2858-1 Lower Hinge Bracket

B39787

N/A

u

SS

09/03/04 (X)

30.0 D28582 Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2858-2 Upper Hinge Bracket

B41439

SS

09/03/04 (X)

31.0 AN526C832R8 Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN526C832R8 Screw

M110023

SS

09/03/04 (X)

32.0 AN526C1032R7 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN526C1032R7

Screw

M110715

SS

09/03/04 (X)

33.0 AN960JD8 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick: Kit Picking

Qty Part Number Description Batch

16 AN960JD8

Washer

M110382

SS

09/03/04 (X)

34.0 AN960JD10 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Pick: Kit Picking

Qty Part Number Description Batch

2 AN960JD10

Washer

M110139

SS

09/03/04 (X)

Date: Friday, 16/01/2009 8:28:14 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 44861

Part Number: D350588041

D2445

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 MS20470AD4-5 Rivet

M109031

N/A

SS 09/03/04 (X)

36.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS20426AD3-4 Rivet

M104374

SS 09/03/04 (X)

37.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Kit Picking

Qty Part Number Description Batch

4 MS21042L3 Nut (or -3)

M110399

SS 09/03/04 (X)

38.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-0811 Screw

M108335

SS 09/03/04 (X)

39.0

MS21042L08

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick: Kit Picking

Qty Part Number Description Batch

10 MS21042L08 Nut (or -08)

M110002

SS 09/03/04 (X)

Date: Friday, 16/01/2009 8:28:14 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 44861

Part Number: D350568041

D2445

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

~~090311~~

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

No kit sold

25 D2445 only

090312

W

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

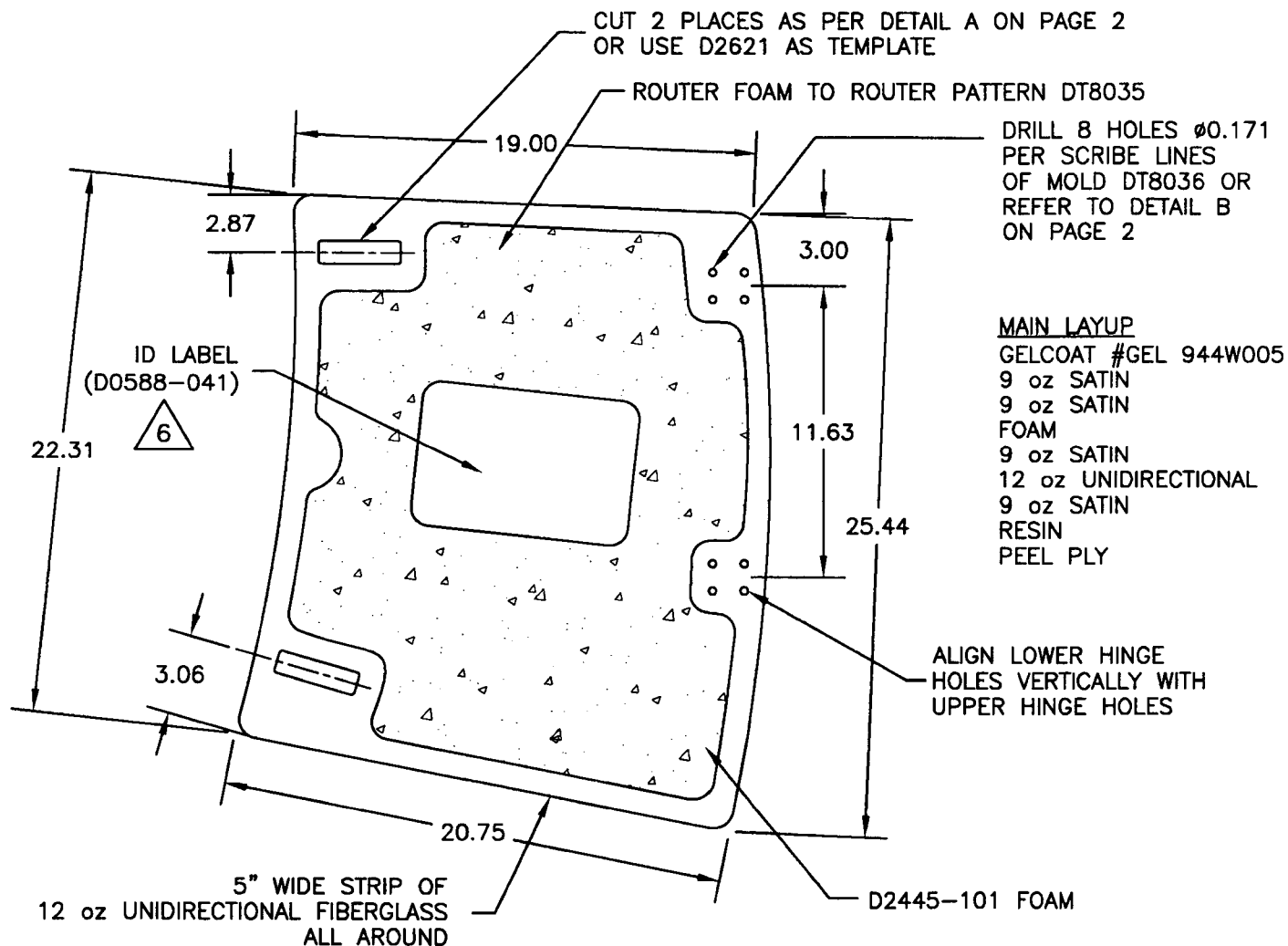
09/03/12

Job Completion



**DART**

|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><b>JB</b>           | DRAWN BY<br><b>CB</b>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2445                                     | REV. D<br>SHEET 1 OF 2 |
| DATE<br>06.06.09              |                                | TITLE<br>AFT BAGGAGE DOOR                                | SCALE<br>1:7           |
| A                             | 97.07.15                       | NEW ISSUE  |                        |
| B                             | 02.01.24                       | ADD D2621; D2445-101                                     |                        |
| C                             | 04.02.09                       | REMOVE D2621; UPDATE NOTES                               |                        |
| D                             | 06.06.09                       | ADD DIMENSIONS TO PERIMETER                              |                        |

**RELEASED**06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 44841

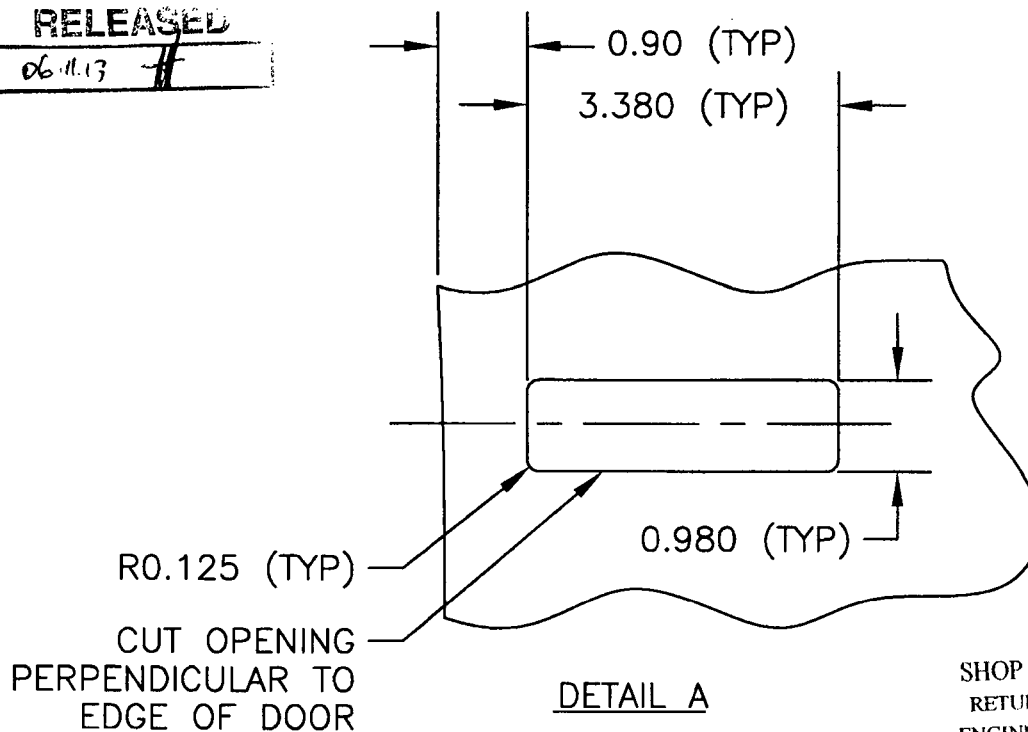
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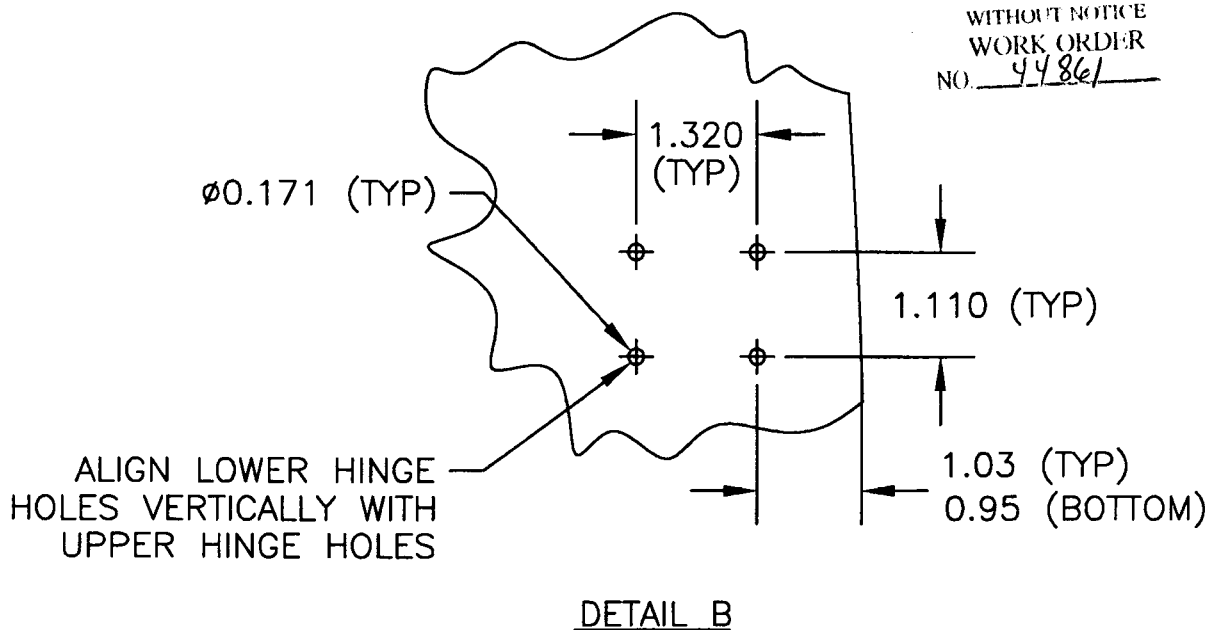


|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><b>JB</b>           | DRAWN BY<br><b>CB</b>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2445                                     | REV. D<br>SHEET 2 OF 2 |
| DATE<br>06.06.09              |                                | TITLE<br>AFT BAGGAGE DOOR                                | SCALE<br>1:2           |

RELEASED  
06.11.13 *[Signature]*



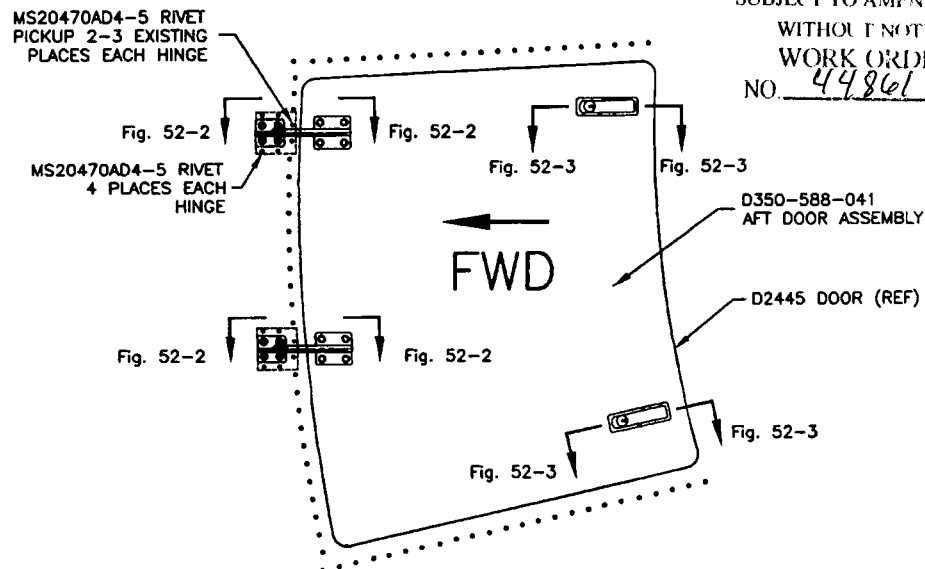
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WITHOUT NOTICE  
WORK ORDER  
NO. 44861



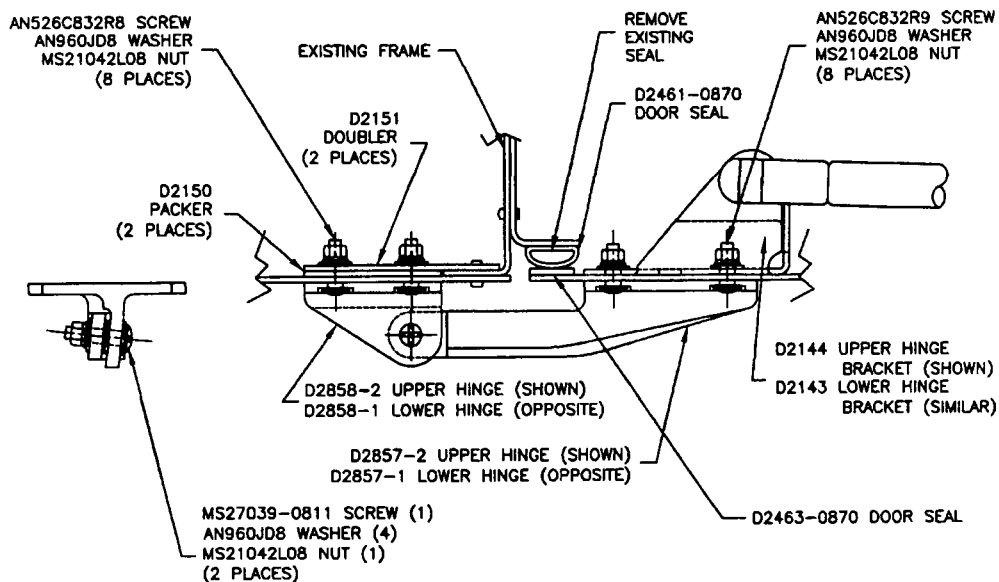
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**Figure 52-1: Baggage Door Outside View**



**Figure 52-2: Hinge Detail**

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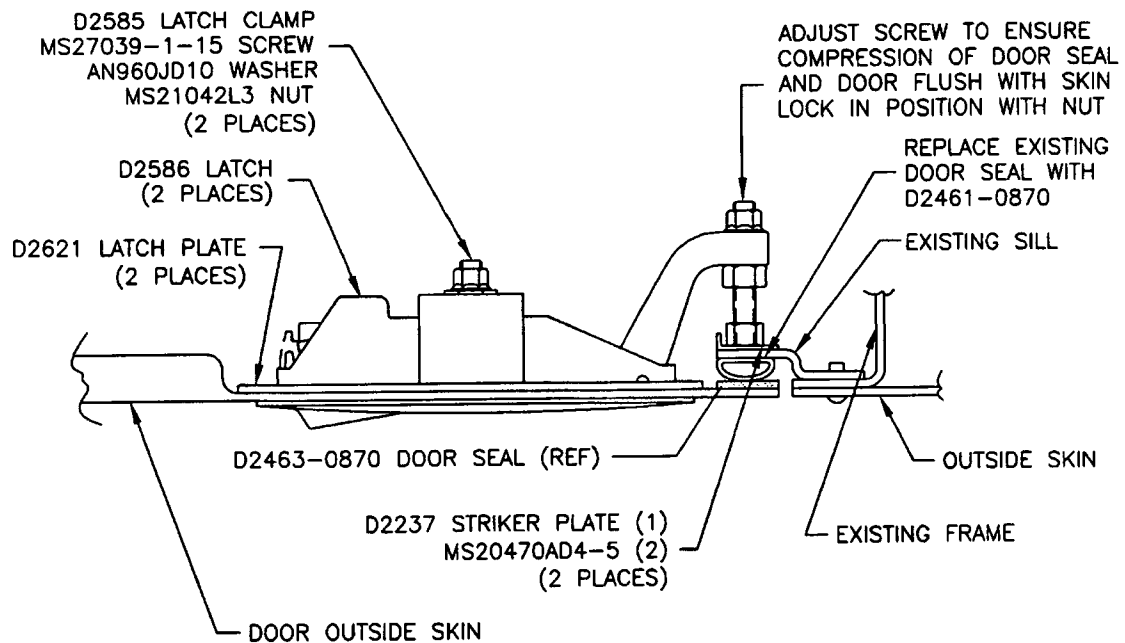
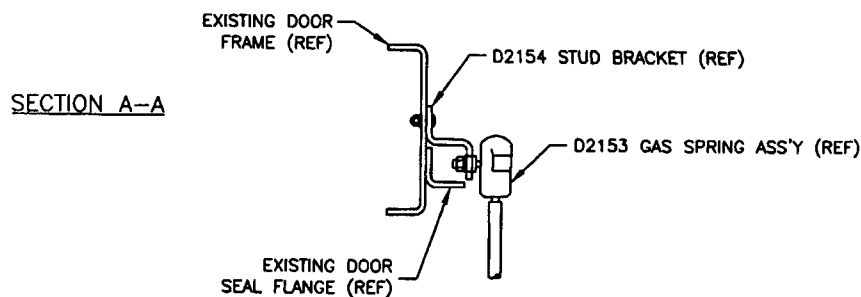
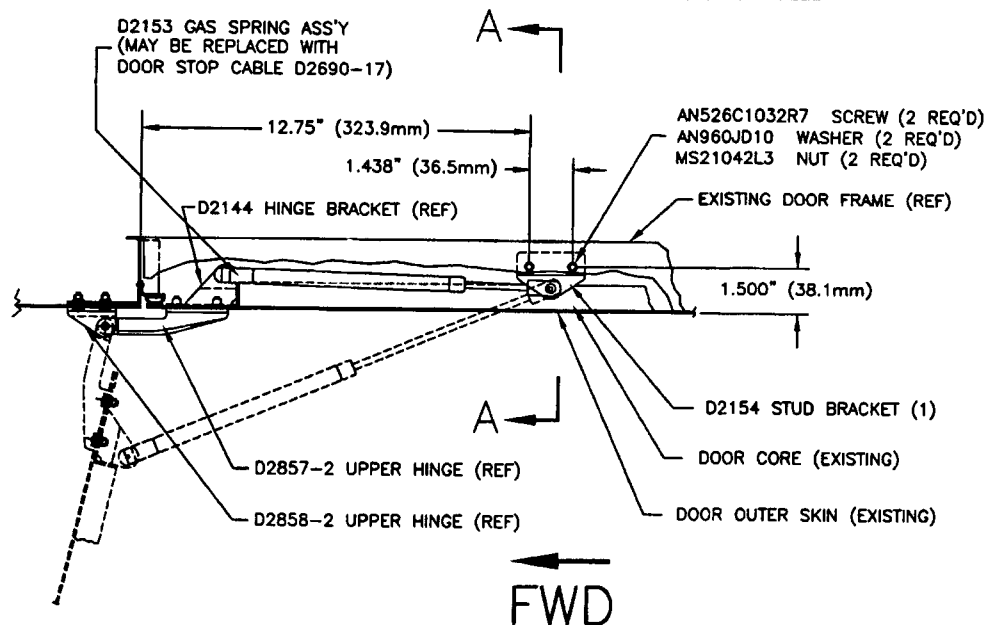


Figure 52-3: Latch Section

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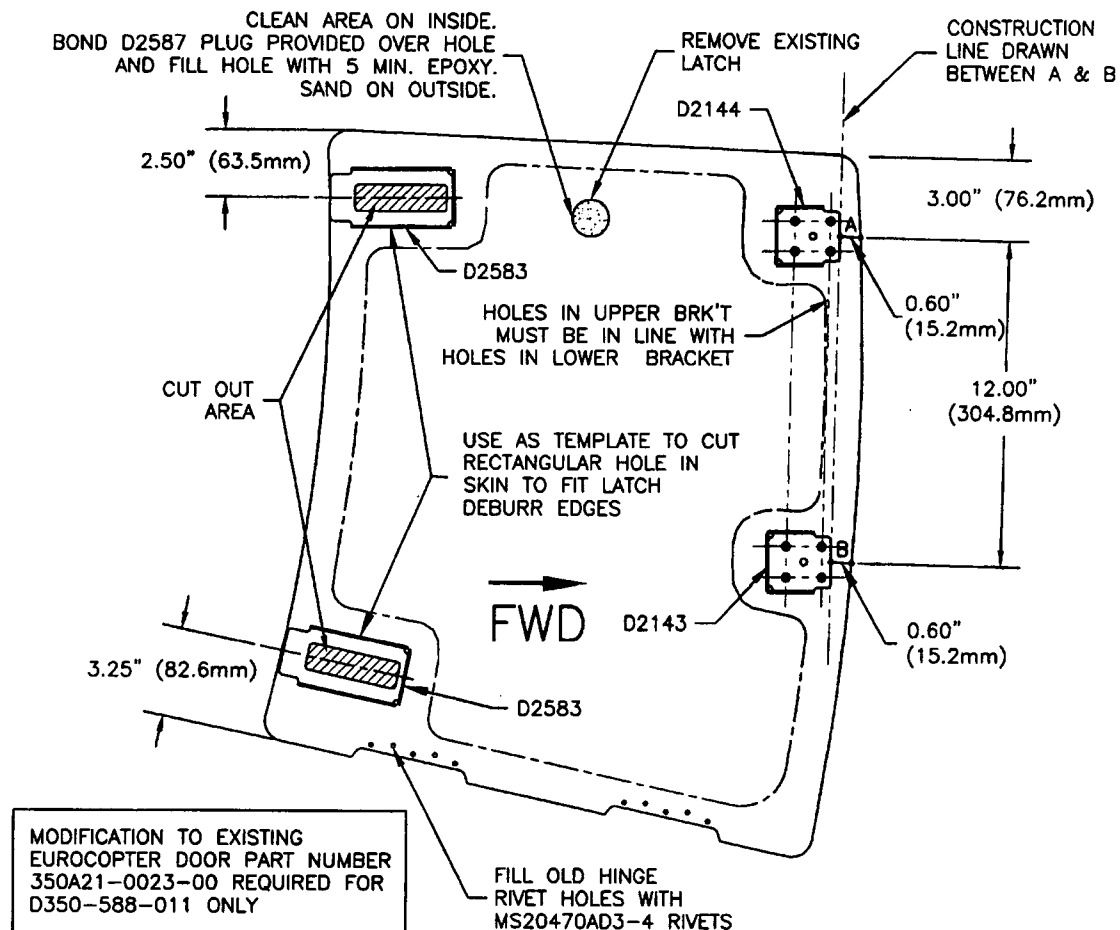


**Figure 52-4: Gas Spring Installation**

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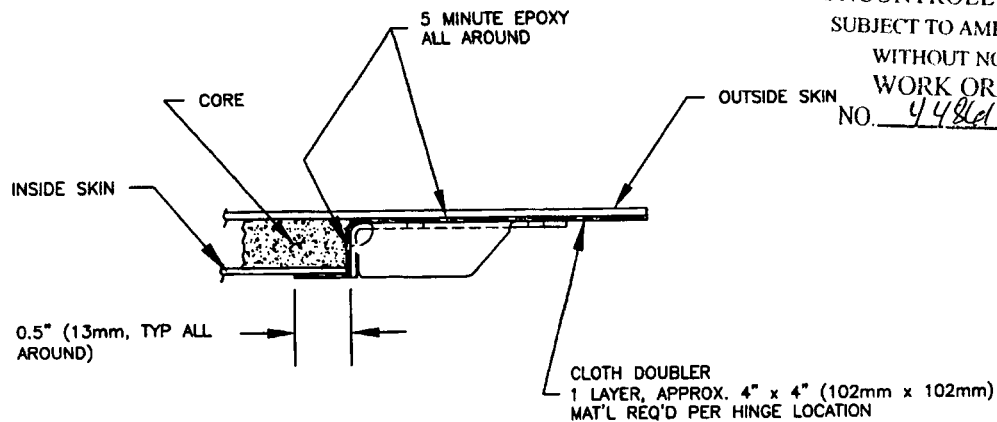


**Figure 52-5: Baggage Door Inside View**

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SECTION B-B

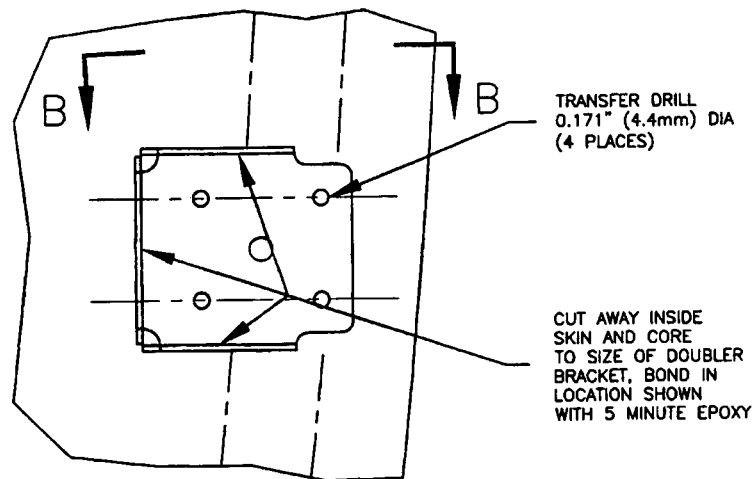
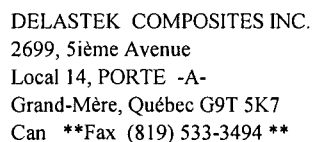


Figure 52-6: Typical Doubler Bracket Installation

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|                   |       |
|-------------------|-------|
| <b>Invoice #</b>  | 13091 |
| <b>Customer #</b> | DART  |

**Warehouse: MAIN**

**Bill to:**

**Contact:** Linda Lacelle

**Ship to:**

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

Accepted by:

Quality department      AQ-357



Date: Mercredi, 2009-01-21 08:21:43  
Utilisateur: Marc Dubé

## Feuille de Procédé

|                          |                     |   |
|--------------------------|---------------------|---|
| Client : DART            | Dart Aerospace Ltd. | Nom Dessin : AFT BAGGAGE DOOR D2445     |
| Numéro Job : 43612       |                     | Numéro Article : DKC134-0013            |
| Numéro Soumission : 2017 |                     | Numéro Dessin : D2445                   |
| Numéro B.A. :            |                     | Projet Numéro : DKC134                  |
| Cette fois : 2009-01-21  | No. B.V. :          | Révision dessin : D                     |
| Prsht Rev. : NC          |                     | Matériel : Fibre 7781 et Résine 411-350 |
| Prem. fois : - -         | Type :              | Date Dûe : 2009-01-28                   |
| Job précédente : 43541   |                     | Qté: 1 UdM: UNITE                       |



Écrit par : \_\_\_\_\_

Vérifié & Approuvé par : \_\_\_\_\_



Commentaires : N° de pièce Dart Aerospace: D2445  
N° Delastek Composites: DKC134-0013  
N° de projet Delastek: DK-362

Process Sheet Rév.: 10 Modification du planning afin d'y inclure le  
N° I.G 0008 ( Primer )

## Produit additionnel

Numéro Job: 

| # Séq.:   | Machine ou Opération: | Description : |
|---|-----------------------|---------------|
| 1.0   | AC0303                | Frekote 44NC  |
| Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)<br>Frekote 44NC |                       |               |

|   |               |                              |
|---|---------------|------------------------------|
| 2.0   | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|   |               |                              |
| Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs<br>PRÉPARATION DU MATÉRIEL DART   |               |                              |

Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 21-1-09 Heure Début: 9:20 Heure Fin: 9:30 Sceau: \_\_\_\_\_



|  |         |                               |
|--|---------|-------------------------------|
| 3.0  | AAC0273 | Gel Coat Blanc N° Gel 944W005 |
| Commentair Qty.: 0.200 GALLON(s)/Unit Total : 0.200 GALLON(s)<br>Gel Coat Blanc N° Gel 944W005 |         |                               |

N° de Lot: 1-6961-1

|  |         |                   |
|--|---------|-------------------|
| 4.0  | AAC0275 | Catalyst N° DDM-9 |
| Commentair Qty.: 0.0320 PINTE(s)/Unit Total : 0.0320 PINTE(s)<br>Catalyst N° DDM-9 |         |                   |

N° de Lot: 1-6118-3

Date: Mercredi, 2009-01-21 08:21:43

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43612

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

5.0 AC0260 Acetone

Commentaire Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s)  
Acetone

6.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 22-1-09 Sceau: Temps Début: 9:30 Temps Fin: 9:45

7.0 GEL COAT. APPLICATION DE GEL COAT



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. ( Visuel du Gel Coat )

Date: 22-1-09 Sceau: Temps Début: 9:45 Temps Fin: 10:00

8.0 AC0409 Tissu à délaminer Release ply B

Commentaire Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)  
Tissu à délaminer Release ply B

9.0 AC0407 Wrightlon 5200 Bleu P3

Commentaire Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)  
Wrightlon 5200 Bleu P3

10.0 AC0408 Feutre de drainage N° Airweave N 10

Commentaire Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)  
Feutre de drainage N° Airweave N 10

Date: Mercredi, 2009-01-21 08:21:43  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43612

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |        |                                  |
|------|--------|----------------------------------|
| 11.0 | AC0752 | Stretchlon 200 poche à vide Vert |
|------|--------|----------------------------------|

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)  
Stretchlon 200 poche à vide Vert

|      |         |   |
|------|---------|---|
| 12.0 | AAC0326 | 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish |
|------|---------|---|

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)  
9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot: 1-6925-1

|      |         |                                 |
|------|---------|---------------------------------|
| 13.0 | AAC0443 | Fiberglass 12 oz Unidirectional |
|------|---------|---------------------------------|

Commentair Qty.: 0.33 VERGE CAR(s)/Unit Total : 0.33 VERGE CAR(s)  
Fiberglass 12 oz Unidirectional

N° de Lot: 1-22202-1

|      |        |                                   |
|------|--------|-----------------------------------|
| 14.0 | AC0098 | Ruban à gommer jaune #: T/AT-200Y |
|------|--------|-----------------------------------|

Commentair Qty.: 1.2500 RL(s)/Unit Total : 1.2500 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

|      |               |                              |
|------|---------------|------------------------------|
| 15.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|------|---------------|------------------------------|



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 01-10-08 Heure Début: 2:30 Heure Fin: 2:50 Sceau:

|      |         |                   |
|------|---------|-------------------|
| 16.0 | AAC0275 | Catalyst N° DDM-9 |
|------|---------|-------------------|

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3



Date: Mercredi, 2009-01-21 08:21:43  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43612

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



| # Séq.: | Machine ou Opération: | Description :                           |
|---------|-----------------------|---|
| 17.0    | AAC0324               | Résine (411B7530) 411-350 promo. 75min. |

Commentaire Qty.: 0.359 KILOGRAMME(s)/Unit Total : 0.359 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6938-1

|      |               |                              |
|------|---------------|------------------------------|
| 18.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|------|---------------|------------------------------|



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 22-1-09 Heure Début: 1:55 Heure Fin: 2:00 Sceau: 

|      |           |                     |
|------|-----------|---------------------|
| 19.0 | LAMINAGE. | LAMINAGE PIÈCE DART |
|------|-----------|---------------------|



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un pli de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 22-1-09 Heure Début: 2:00 Heure Fin: 2:15 Sceau:  

|      |                |                       |
|------|----------------|-----------------------|
| 20.0 | POCHE À VIDE 1 | FAIRE LA POCHE À VIDE |
|------|----------------|-----------------------|



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre qui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 22-1-09 Heure Début: 2:15 Heure Fin: 2:30 Sceau:  

Curing début: 2:00 Curing Fin: \_\_\_\_\_

Date: Mercredi, 2009-01-21 08:21:43

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43612

Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

21.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0042 PINTE(s)/Unit Total: 0.0042 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3

22.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6938-1

23.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 21-1-09 Heure Début: 2:30 Heure Fin: 2:40 Sceau: 34

24.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)  
Polybond B46F

N° de Lot: 1-6520-1

25.0 DKC134-0029 Foam Core N° D2445-101 ( Pour AFT Baggage Door )

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Foam Core N° D2445-101 ( Pour AFT Baggage Door ) # 43527

26.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 23-01-09 Heure Début: 12:50 Heure Fin: 1:05 Sceau: 34 7

Date: Mercredi, 2009-01-21 08:21:43  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43612

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |                |                       |
|------|----------------|-----------------------|
| 27.0 | POCHE À VIDE 1 | FAIRE LA POCHE À VIDE |
|------|----------------|-----------------------|





Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 23-1-09 Heure Début: 1:05 Heure Fin: 1:15 Sceau:  

Curing Début: 12:50 Curing Fin: 3:20

|      |         |                   |
|------|---------|-------------------|
| 28.0 | AAC0275 | Catalyst N° DDM-9 |
|------|---------|-------------------|

Commentair Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3

|      |         |   |
|------|---------|---|
| 29.0 | AAC0324 | Résine (411B7530) 411-350 promo. 75min. |
|------|---------|---|

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.


N° de Lot: 1-6938-1

|      |               |                              |
|------|---------------|------------------------------|
| 30.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|------|---------------|------------------------------|



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 26-1-09 Heure Début: 10:25 Heure Fin: 10:30 Sceau: 

|      |           |                     |
|------|-----------|---------------------|
| 31.0 | LAMINAGE. | LAMINAGE PIÈCE DART |
|------|-----------|---------------------|



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes

Date: Mercredi, 2009-01-21 08:21:43  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43612

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 26-1-09 Heure Début: 10:30 Heure Fin: 11:00 Sceau:



32.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 26-1-09 Heure Début: 11:00 Heure Fin: 11:10 Sceau:



Curing Début: 10:30 Curing Fin: 15:20

33.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ".

Date: 26 jan 09 Heure Début: 15:20 Heure Fin: 15:30 Sceau:



34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE COMPOSITES DART

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 27-1-09 Heure Début: 3:50 Heure Fin: 4:20 Sceau:



Date: Mercredi, 2009-01-21 08:21:44  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43612

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

35.0 AAC0062 Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Label N° D0588-041

36.0 AAC0444 Surface Veil

Commentair Qty.: 0.07 VERGE CAR(s)/Unit Total: 0.07 VERGE CAR(s)  
Surface Veil

37.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)  
Résine Mia-Poxy

38.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 PINTE(s)/Unit Total: 0.007 PINTE(s)  
Durcisseur 95 Pour Résine Mia-Poxy

39.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
FABRICATION GÉNÉRALE DART

Coller le abel N° D0588-041 selon les séquences suivantes:

- 1- Surface Veil
- 2- Label
- 3- Surface Veil

Laisser scher pendant 4 heures.

Date: 4-2-09 Heure Début: 8:30 Heure Fin: 8:45 Sceau:

40.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.025 UNITE(s)/Unit Total: 0.025 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6893-1

41.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.020 UNITE(s)/Unit Total: 0.020 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

42.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs  
FINITION PIÈCE DART

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 28-1-09 Heure Début: 3:30 Heure Fin: 4:00 Sceau:

Date: Mercredi, 2009-01-21 08:21:44  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43612

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

43.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-21723-1

44.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
Dupont Activator - Reducer Chromabase N° 7775S

45.0 PRIMER APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 07/02/09 Sceau:

Quantité: 1 Date: 05/02/09 Sceau:

Quantité: 1 Date: 09/02/09 Sceau: Remark

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

46.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
INSPECTION PIÈCE DART

Faire l'inspection selon le dessin N° D2445.

Date: 11-02-09 Heure Début: 8h00 Heure Fin: 8h10 Sceau:

47.0 EMBALLAGE EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 11-2-09 Sceau:

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_